

# Work Order ID 53684

November 12, 2009 9:14:22 AM



## PRELIMINARY ISSUE

Page 1

Item ID: D4010-1

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4010	B-PRELIM

100		0.00							
	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks to fit frame size								

OK 09/11/12 (X)

110		0.00							
	THERMOFORMING MACHINE								
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4010-1 and Folio FTA067 temp using tool DT 9540 □ Dwg. Rev. <u>PREL</u> □ Folio Rev. <u>B</u>								

OK 09/11/12 (X)

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								

OK 09/11/12 (X)

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Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<i>JB</i>	<i>29</i>	<i>11-12-09</i>	
140  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING  Memo Trim to Finished Dimensions as per dwg D4010-1	0.00  0.00							<i>PL 09/11/12</i> <i>(X)</i>
150  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo Check dimensions to ensure conformity to drawing tolerances.	0.00  0.00							<i>PL 09/11/12</i> <i>(X)</i>

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Item ID: D4010-1

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

USED FOR TEST FIT  
ONLY. SCRAP & RETURN  
FOR R.E.D.

PL 09/11/13 (13)

POSITIVE RECALL

EFFECTIVE 11/12 AUTH 11

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

PL 09-11-27  
RD0324A 1000

# Picklist Print

November 12, 2009 9:14:21 AM

Page 1

Work Order ID: 53684



Parent Item: D4010-1



Parent Item Name: Bearpaw

Start Date: 11/12/09

Required Date: 11/13/09

Comments: IPP Rev B 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.  
DL. Verified by:DD.

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M-ALXTRAB-S.300		Purchased	No			100	sf	1,065.611	7.4779			



Alextra ET 0.300 sheet



Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

113108

1065.6112

1065.6112

1 wh 09/11/12

DART AEROSPACE LTD		Work Order: 53684
Description:		Part Number: D4010-1
Inspection Dwg: PREL	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DA Date: 09/11/12

#### TRIMMING SECTION

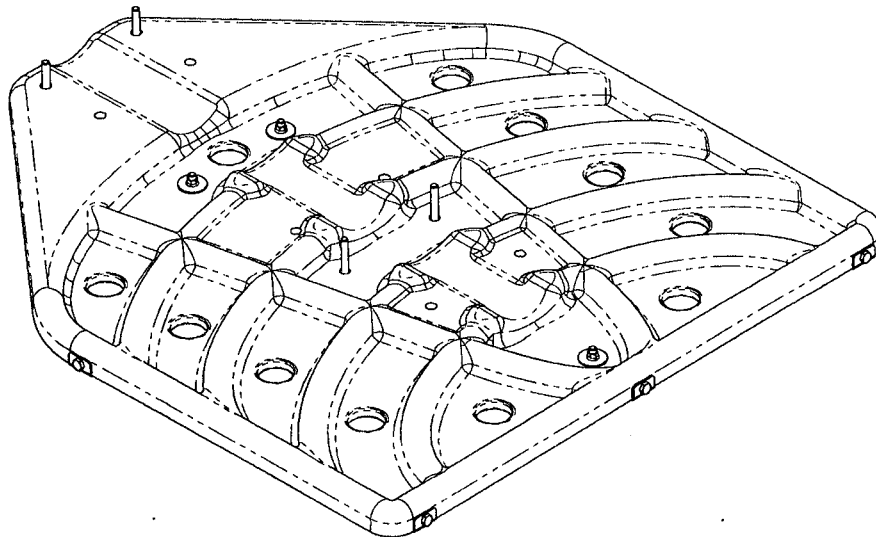
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.0"	± 0.100	1.01"	✓			
Ø 1.25"	± 0.13	Ø 1.26"	✓			
Ø 0.375	± 0.03	Ø 0.376"	✓			
N/A Used for Test Fit R.E.D. Only Dt. 09/11/12						

Measured by: DA Date: 09/11/12

Audited by: DA 09.11.12 Date: 09.11.12

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



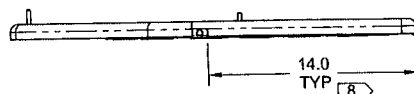
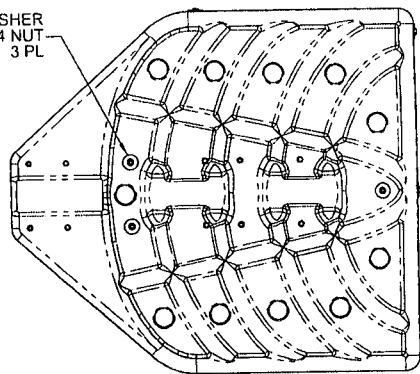
wb  
53684

**D4010-041 BEARPAW ASSEMBLY (407)**

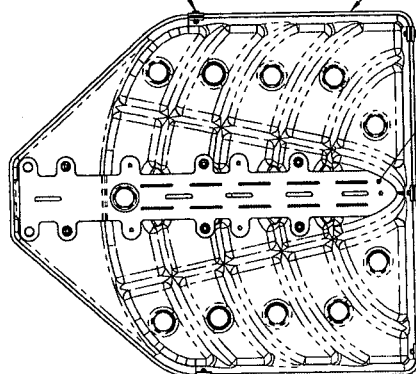
**PRELIMINARY ISSUE**

P1	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED; ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. P1
MFG. APPR.		<b>D4010-041</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BEARPAW (407)</b>	NTS
DATE	09.11.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

D3456-1 WASHER  
MS21042L4 NUT  
3 PL



AN3C5A BOLT  
D4015-041 WEARBAR  
MS21043-3 NUT



AN3C5A BOLT  
D4015-041 WEARBAR  
MS21043-3 NUT

D4010-1  
BEARPAW

AN3C5A BOLT  
D4015-041 WEARBAR  
MS21043-3 NUT

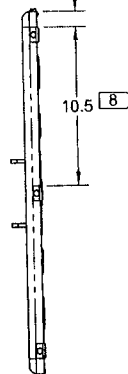
D4013-041 WEARPLATE  
ASSEMBLY

AN3C5A BOLT  
D4015-041 WEARBAR  
MS21043-3 NUT

AN3C5A BOLT  
D4015-041 WEARBAR  
MS21043-3 NUT

**D4010-041 BEARPAW ASSEMBLY (407)**

1.0  
TYP



ITEM	QTY	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
3	3	D3456-1	WASHER
4	1	D4010-1	BEARPAW
5	1	D4013-041	WEARPLATE ASSEMBLY
6	5	D4015-041	WEARBAR
21	5	AN3C5A	BOLT
24	5	MS21043-3	NUT
25	3	MS21043-4	NUT

W/O 53684

**PRELIMINARY ISSUE**

**D4010-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.42 lbs
- 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE ON AN3 NUTS: 15-20 in-lb

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. P1
MFG. APPR.		D4010-041 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		BEARPAW (407) NTS
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